

# Work Order ID 68808

Thursday, April 21, 2011 9:12:47 AM



Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 4/21/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2892	Rev A

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

*amk 11/05/26*

*14* *0*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

*amk 11/05/26*

*14* *0*

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

*B.A 11/05/30*

*14* *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68808**

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Page 2

Item ID: D2892-1

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Item Name: Support

Start Date: 4/21/2011 Start Qty: 14.00

Required Date: 4/26/2011 Req'd Qty: 14.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

140

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150

Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

Memo

0.00

14x 2 M-1 11/06/01

14 0 BK 11-6-1

2T 11-06-02 (x14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68808**

Thursday, April 21, 2011 9:12:47 AM

Page 3

Item ID: D2892-1

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Setup Start

Revision ID:

Stop

Item Name: Support

Start Date: 4/21/2011 Start Qty: 14.00

Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 14.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/09

ME

11-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 9:12:52 AM

Page 1

Work Order ID: 68808



Parent Item: D2892-1



Parent Item Name: Support


Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP C 02.11.26 Added P/O KJ  
IPP D 08.03.19 Re-format EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077 		Manufactured	No			110	Each	0.0000	0.5	7			

D2892-1 TURNING DETAIL

B66732  
~~256115~~ X 7 omk 11/05/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68808
<b>Description: Ø2.500 Support</b>		<b>Part Number:</b>	D2892-1
<b>Inspection Dwg: D2892</b>	<b>Rev: A</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	.132
AB	0.290	0.310		.300	.300	.303	.302	.304
AC	0.040	0.060		.050	.050	.048	.049	.050
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.247	.248	.249	.249	.250
AF	0.188	0.193		.188	.188	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.138	1.137	1.137	1.141	1.140
AI	0.454	0.474		.464	.464	.465	.466	.463
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.262	.262	.262	.262	.262
AM	1.663	1.683		1.676	1.676	1.677	1.677	1.677
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.783	2.783	2.783	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	CMR	<b>Date:</b>	11/05/26
<b>Audited by:</b>	H.A	<b>Date:</b>	11/05/30
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68808
<b>Description: Ø2.500 Support</b>		<b>Part Number:</b>	D2892-1
<b>Inspection Dwg: D2892</b>	<b>Rev: A</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.115	0.135		.132	.131	.132	.132	.132
AB	0.290	0.310		.302	.305	.305	.303	.303
AC	0.040	0.060		.048	.047	.047	.050	.050
AD	0.115	0.135		.125	.125	.125	.125	.125
AE	0.240	0.260		.249	.248	.248	.250	.250
AF	0.188	0.193		.189	.189	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.137	1.141	1.138	1.140	1.140
AI	0.454	0.474		.463	.464	.465	.467	.467
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.262	.262	.262	.262	.262
AM	1.663	1.683		1.677	1.677	1.677	1.677	1.677
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.783	2.783	2.783	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	SMK	<b>Date:</b>	11/05/27
<b>Audited by:</b>	H.A	<b>Date:</b>	11/05/30
<b>Prototype Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	



DART AEROSPACE LTD		Work Order:	68808
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1/	12	13	14	8
HAAS Section								
AA	0.115	0.135		.132	.132	.132	.132	
AB	0.290	0.310		.301	.304	.302	.301	
AC	0.040	0.060		.048	.049	.048	.045	
AD	0.115	0.135		.125	.125	.125	.125	
AE	0.240	0.260		.250	.250	.250	.250	
AF	0.188	0.193		.180	.190	.190	.196	
AG	0.240	0.260		.250	.250	.250	.250	
AH	1.126	1.146		1.140	1.139	1.141	1.138	
AI	0.454	0.474		.465	.467	.469	.469	
AJ	0.240	0.260		.250	.250	.250	.250	
AK	0.053	0.073		.063	.063	.063	.063	
AL	0.257	0.262		.262	.262	.262	.262	
AM	1.663	1.683		1.676	1.677	1.676	1.676	
AN	0.053	0.073		.063	.063	.063	.063	
AO	0.022	0.042		.032	.032	.032	.032	
AP	2.779	2.789		2.782	2.783	2.782	2.782	
AQ								
AR								
AS								
AT								
Accept/Reject								

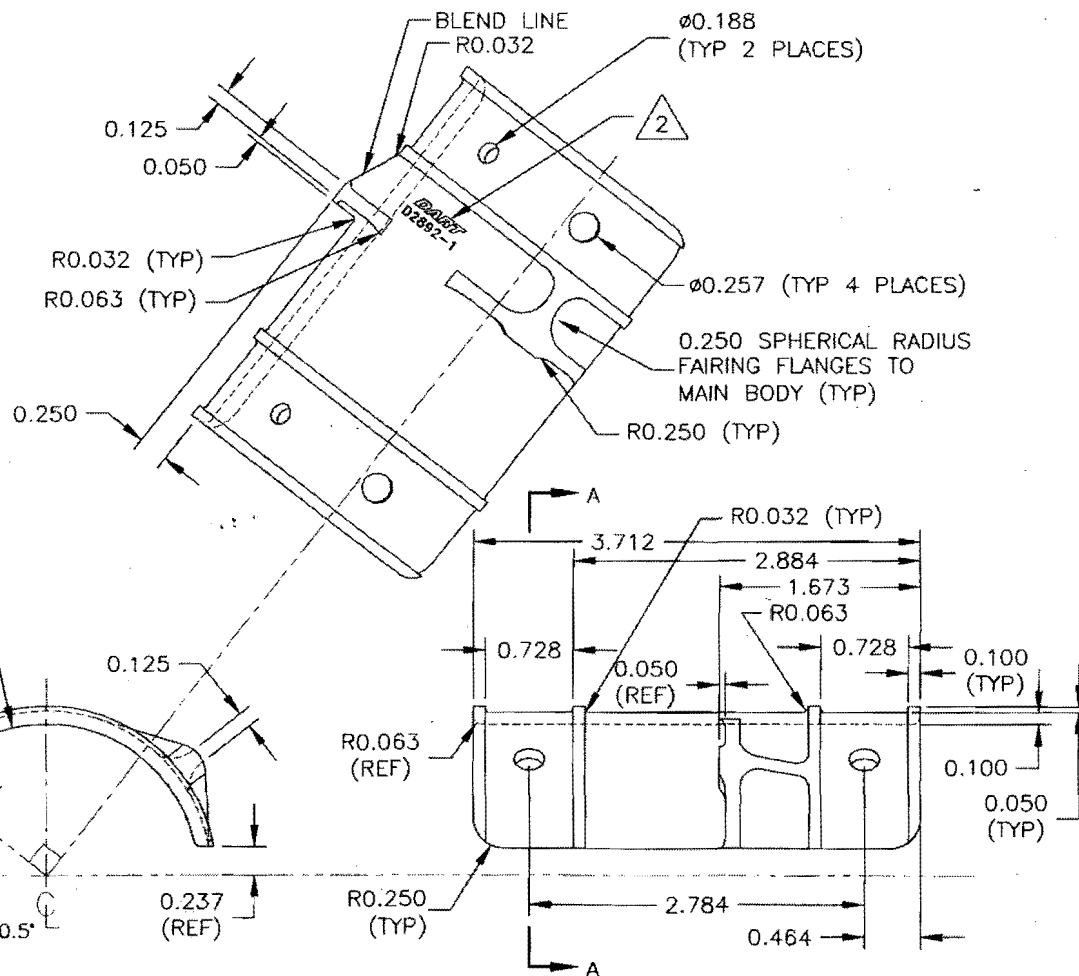
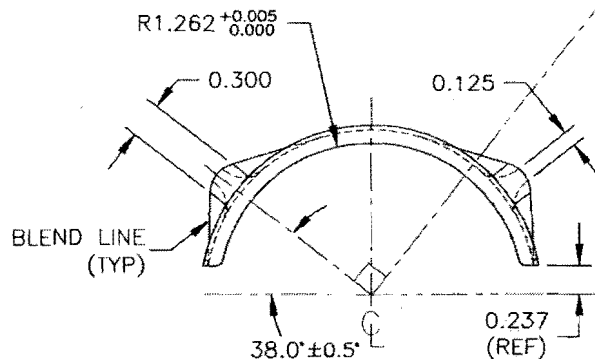
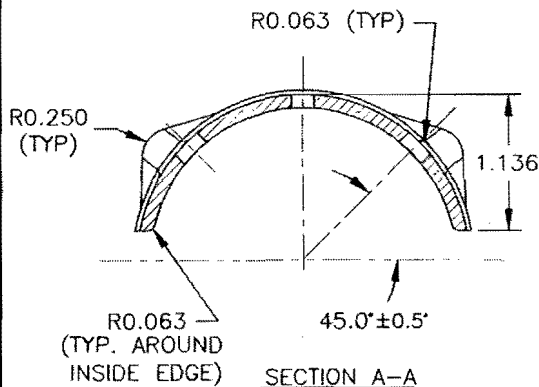
Measured by:	<i>amf</i>	Date:	11/05/30
Audited by:	<i>B.A</i>	Date:	11/05/30
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	



D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 41808

2011-09-21

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A	00.11.17	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2892
DATE	00.11.17	TITLE ø2.500 SUPPORT
		REV. A SHEET 1 OF 1 SCALE 1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries